

Date: Tuesday, 11/21/2006 10:49:08 AM
User: Kim Johnston

ASAP! Need for Friday 24/11
Process Sheet **Dart Aerospace Ltd.**

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 29559
Estimate Number : 12538
P.O. Number : *N/A*
This Issue : 11/21/2006 **S.O. No.** : *N/A*
Prsht Rev. : NC
First Issue : *N/A* **Type** : SMALL / MED FAB
Previous Run : 28797
Written By : *[Signature]*
Checked & Approved By : *[Signature]* 061121
Comment : Est Rev: A New Issue 06-09-27 JLM

Drawing Name : BRACKET
Part Number : D35461
Drawing Number : D3546 REV A
Project Number : N/A
Drawing Revision : A
Material : *N/A*
Due Date : 11/23/2006 **Qty:** 20 **Um:** Each

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 ~~M6061T6S080~~ *M304S186A* ~~6061 T6-080 Sheet~~



Comment: Qty.: 0.2205 sf(s)/Unit Total : 4.4100 sf(s)

~~6061 T6 aluminum sheet 080 Sheet~~ *M304S186A*

Batch: *M120997* *ml 061121* (20)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3546

Dwg Rev: *A*

Prog Rev: *A* *ml 061121* (20)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06/11/21 (20)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3546

SB 06/11/21 (17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 10:49:08 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 29559

Part Number: D35461

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ND 06/11/23 (17)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 11 21 (17)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PV 4/4/27 (17)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PV 4/4/27 (17)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

17
DB 06/11/08

Job Completion



C206/11/28




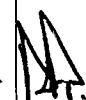
→
PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

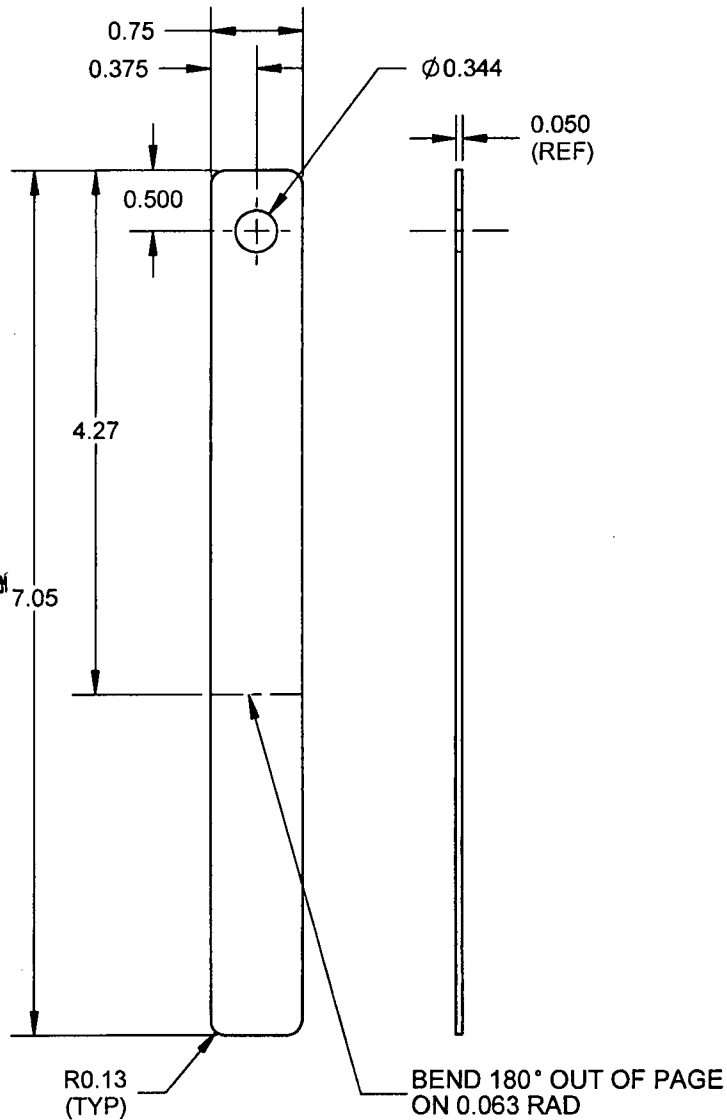
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

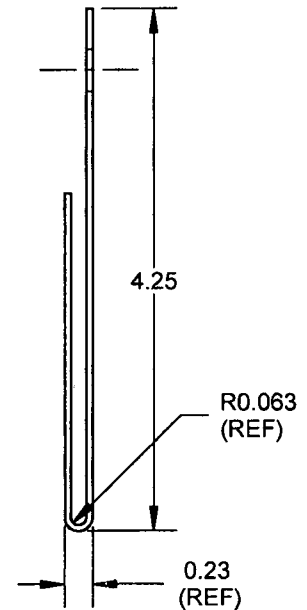
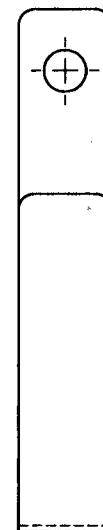
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/23	5	3 piece out of tolerance		Scrap & destroy (Made a tool for bending)	SB 06/11/23	 06/11/23		 06/11/23

NOTE: Date & initial all entries

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>gp</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3546	REV. A SHEET 1 OF 1
DATE 06.09.15	TITLE CLIP	SCALE 1:1	
REV A	DATE 06.09.15	DESCRIPTION NEW ISSUE	



D3546-1F FLAT PATTERN



D3546-1 CLIP

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL 0.050 THICK (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29559

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